

Work Order ID 120311

Wednesday, June 04, 2014 3:01:43 PM

120311

Page 1

Item ID: D3500-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Saddle

Stop

NS2

Start Date: 6/04/14

Start Qty: 24.00

24

Cust Item ID:

Required Date: 6/04/14

Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 14-06-06

Tooling:

Date:

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3500	C

100	HAAS CNC VERTICAL MACHINING #1	0.00	DAS 25 9-89 14-07-18
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100

HAAS 1

HAAS CNC vertical machine #1

Memo

0.00

Program Batch No. 120311 Double check by: M 1-Machine Step No 1
per Folio FA641 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA641 and inspect p

110	QC2- Inspect parts off machine FAI/FAIB	0.00	DAS 25 9-89 14-07-18
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110

QC

Quality Control

Memo

0.00

120	QC8- Inspect parts - second check	0.00	DAS 20 9-89 14-07-22
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120

QC

Quality Control

Memo

0.00

PTO →

DQA:

Date: 14/08/27

WORK ORDER NON-CONFORMANCE / UPDATE

QA CI

Date: 14-8-16

DART
AEROSPACE

Work Order update only

Work Order: <u>120 311</u> Part No. <u>P3500-1</u> NCR No. <u>14-4151</u>				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>				Skid-tube <input type="checkbox"/> Machining <input checked="" type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>		Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>		Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>		Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>					
Root Cause		Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector			
Design		14.07.18	100	2	USED 3/16 RAD TOOL WAS SUPPOSED TO BE .250 RAD TOOL. RIB UNDER SIZE. RC Operator used wrong tool./ No Recalibration of setup.		DAS 16 9-89 052042 14/07/22	Scrap + Destroy, Replace, B 110225		14.07.18 DAS 37 9-89 23.31	DAS 16 9-89 14/07/22	DAS 16 9-89 052042 14/07/22			
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material															
Operator	A														
Offset/Setup															
Process															
Supplier															
Training															
Transport															
Unapproved															
FAULT CATEGORY															
Landing Gear Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence Wave/Twist in Tube				General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish Fit/Function				Folio/Program Grain Hardware Inspection Incomplete/Unqualified Instructions Incomplete/Unclear Misaligned/off center Mislabeled Misread Off-set Out of Calibration Out of Sequence				Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge		Pressure/Forced Set-up Temperature/Cure Weld Wrong Stock Pulled Other	

Work Order ID 120311

Wednesday, June 04, 2014 3:01:43 PM

120311

Page 2

Item ID: D3500-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Saddle

Stop

NS2

Start Date: 6/04/14

Start Qty: 24.00

24

Cust Item ID:

Required Date: 6/04/14

Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

130

Chemical Conversion Coat per QSI005 4.1

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

HandFinish

Hand Finishing

140

140

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

111284959

Memo

0.00

START TIME:

10:05

OVEN TEMPERATURE:

FINISH TIME:

10:35

150

150

QC

Quality Control

QC3- Inspect Part Finish

0.00

83
27
9:89

0.00

14/07/14

DAS
34

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General									
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function		<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled		<input type="checkbox"/> Other		

Work Order ID 120311

Wednesday, June 04, 2014 3:01:43 PM

120311

Page 3

Item ID: D3500-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Saddle

Stop

NS2

Start Date: 6/04/14

Start Qty: 24.00

24

Cust Item ID:

Required Date: 6/04/14

Req'd Qty: 24.00

24

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

160

Identify as per dwg & Stock Location:

160

Packaging

Packaging

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

14/1/25 24 DAS
32
9.89

Memo

57406

0.00

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Quality Control

Memo

0.00

MLJ 14-07-25

MLJ 14-07-25

DQA: _____ Date: _____

QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS										
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>								
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>								
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>								
			Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>									
Root Cause	Date	Step	Qty	Description of work order update or non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector				
Design															
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material															
Operator															
Offset/Setup															
Process															
Supplier															
Training															
Transport															
Unapproved															
FAULT CATEGORY															
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function				<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence				<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	
														<input type="checkbox"/> Other	

Picklist Print

Wednesday, June 04, 2014 3:01:42 PM

Page 1

Work Order ID: 120311

120311
D3500-1

Parent Item: D3500-1

Parent Item Name: Saddle

Start Date: 6/04/14

Required Date: 6/04/14

Start Qty: 24.00

Required Qty: 24.00

Comments: -- IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	114.0000	1	24			DAS 37 9.89

D6102-013

Saddle Billet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	52	
104299	22	
105041	20	Q0
105554	10	
MAT041	20	
117029	20	
MAT046	42	
109518	10	
110225	12	4+2
110994	8	
111533	12	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS					
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>		
NCR No. _____	Suspected Unapproved <input type="checkbox"/>			Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>		
				Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>		
				Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>			

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear		General					
Bending		Bend		Folio/Program		Outside Dimensions	
Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance	
Cracks		Broken/Damage/Defect		Hardware		Part Incorrect	
Crimp/Kink/Ripple/Wave		Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing	
Cuffs		Contamination		Instructions Incomplete/Unclear		Part Moved	
Crushing		Countersink		Misaligned/off center		Positioned Wrong	
Heat Treat		Cut Too Short		Mislabeled		Power Loss/Surge	
Inspection Strip in Tube		Drawing		Misread		Pressure/Forced	
Marks/Chatter		Drill Holes		Off-set		Set-up	
Turning Sequence		Finish		Out of Calibration		Temperature/Cure	
Wave/Twist in Tube		Fit/Function		Out of Sequence		Weld	
						Wrong Stock Pulled	
						Other	

DART AEROSPACE LTD				Work Order:	120311
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.487	.487	.487	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.373	.373	.373	.375		
F	0.490	0.510		.497	.496	.498	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.588	1.588	1.588		
J	0.240	0.260		.244	.247	.247	.246		
K	0.490	0.510		.495	.500	.500	.500		
L	3.590	3.650		3.62	3.62	3.62	3.620		
M	0.315	0.322		.318	.318	.318	.316		
N	0.256	0.262		.260	.260	.260	.259		
O	6.500	6.520		6.505	6.510	6.510	6.510		
P	5.990	6.010		5.998	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.055	.055	.055		
Y	0.100	0.120		.100	.100	.100	.100		
AA	R1.125	R1.145		1.138	1.134	1.134	1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.249	.254	.254	.254		
AE	1.810	1.830		1.823	1.823	1.823	1.821		
AF	0.240	0.260		.251	.250	.250	.251		
AG	0.140	0.160		.152	.151	.151	.151		
AH	0.140	0.160		.157	.152	.154	.155		
AI	0.140	0.160		.158	.151	.155	.155		

Accept/Reject

DAS

Measured by:	37	SL	Audited by:	20
Date:	9-89	11-07-18	Date:	9-89 14-07-22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AK

DART AEROSPACE LTD				Work Order:	120311
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	X5	X6	X7	X8	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.499	.500	.499	.499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.588	1.588	1.588		
J	0.240	0.260		.246	.246	.246	.246		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.259	.259	.259	.259		
O	6.500	6.520		6.510	6.510	6.509	6.509		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.551	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.25	.25	.25	.25		
X	0.040	0.060		.055	.055	.055	.055		
Y	0.100	0.120		.100	.100	.100	.100		
AA	R1.125	R1.145		1.134	1.134	1.134	1.134		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.254	.254	.254	.254		
AE	1.810	1.830		1.821	1.821	1.821	1.823		
AF	0.240	0.260		.251	.251	.250	.250		
AG	0.140	0.160		.151	.151	.151	.151		
AH	0.140	0.160		.155	.155	.155	.155		
AI	0.140	0.160		.155	.154	.154	.154		
Accept/Reject				DAS					

Measured by:	SL	Audited by:	20
Date:	14-07-19	Date:	08-07-22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

DART AEROSPACE LTD				Work Order:	20311
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	19	20	311	412	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.498	.500	.499	.499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.588	1.587	1.587		
J	0.240	0.260		.246	.246	.246	.247		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.259	.259	.259	.259		
O	6.500	6.520		6.509	6.516	6.509	6.510		
P	5.990	6.010		6.000	6.000	5.991	5.991		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.548		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.055	.055	.055		
Y	0.100	0.120		.100	.100	.100	.100		
AA	R1.125	R1.145		1.134	1.134	1.133	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.255	.255	.255	.255		
AE	1.810	1.830		1.822	1.822	1.822	1.822		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.151	.151	.151	.151		
AH	0.140	0.160		.155	.155	.156	.155		
AI	0.140	0.160		.155	.155	.155	.154		
Accept/Reject				DAS					
				20					

Measured by:	SL	Audited by:	9-89
Date:	14-7-20	Date:	14-07-22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AK

DART AEROSPACE LTD				Work Order:	120311
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1/3	2/4	3/5	4/6	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.500	.498	.498	.498		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.587	1.587	1.587		
J	0.240	0.260		.250	.249	.251	.251		
K	0.490	0.510		.500	.500	.498	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.259	.259	.259	.259		
O	6.500	6.520		6.509	6.507	6.509	6.506		
P	5.990	6.010		6.002	6.002	5.999	6.006		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.551	.551	.550	.551		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.055	.055	.055		
Y	0.100	0.120		.100	.100	.100	.100		
AA	R1.125	R1.145		1.133	1.133	1.133	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.250	.255	.255	.255		
AE	1.810	1.830		1.822	1.822	1.823	1.823		
AF	0.240	0.260		.250	.251	.251	.251		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.156	.155	.156	.156		
AI	0.140	0.160		.154	.154	.156	.155		
Accept/Reject				DAS					

Measured by:	SL	Audited by:	20
Date:	14-7-20	Date:	08-07-22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

DART AEROSPACE LTD				Work Order:	120311
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	17	18	19	20	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.499	.498	.499	.498		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.588	1.588	1.588		
J	0.240	0.260		.251	.251	.251	.251		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.259	.259	.259	.259		
O	6.500	6.520		6.508	6.508	6.508	6.508		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.055	.055	.055		
Y	0.100	0.120		.100	.100	.100	.100		
AA	R1.125	R1.145		1.133	1.133	1.133	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.255	.255	.255	.254		
AE	1.810	1.830		1.823	1.823	1.822	1.822		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.156	.156	.156	.155		
AI	0.140	0.160		.155	.156	.155	.155		

Accept/Reject

DAS

Measured by:	SL	Audited by:	20
Date:	14-7-20	Date:	9-89 14-07-22

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA

DART AEROSPACE LTD				Work Order:	20311
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	21	22	23	24	By	Date
A	0.483	0.490		.486	.486	.486	.486		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.375	.375	.375	.375		
F	0.490	0.510		.499	.499	.499	.499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.588	1.588	1.588	1.588		
J	0.240	0.260		.250	.250	.251	.250		
K	0.490	0.510		.499	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.316	.316	.316	.316		
N	0.256	0.262		.259	.259	.259	.259		
O	6.500	6.520		6.509	6.508	6.509	6.508		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.551	.550	.550	.550		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.055	.055	.055	.055		
Y	0.100	0.120		.100	.100	.100	.100		
AA	R1.125	R1.145		1.133	1.133	1.133	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.253	.254	.254	.254		
AE	1.810	1.830		1.823	1.823	1.823	1.823		
AF	0.240	0.260		.250	.250	.250	.250		
AG	0.140	0.160		.150	.150	.150	.150		
AH	0.140	0.160		.156	.156	.156	.156		
AI	0.140	0.160		.155	.155	.155	.155		

Accept/Reject

DAK

Measured by:	SL
Date:	14-7-21

Audited by:	20
Date:	9-8-21

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

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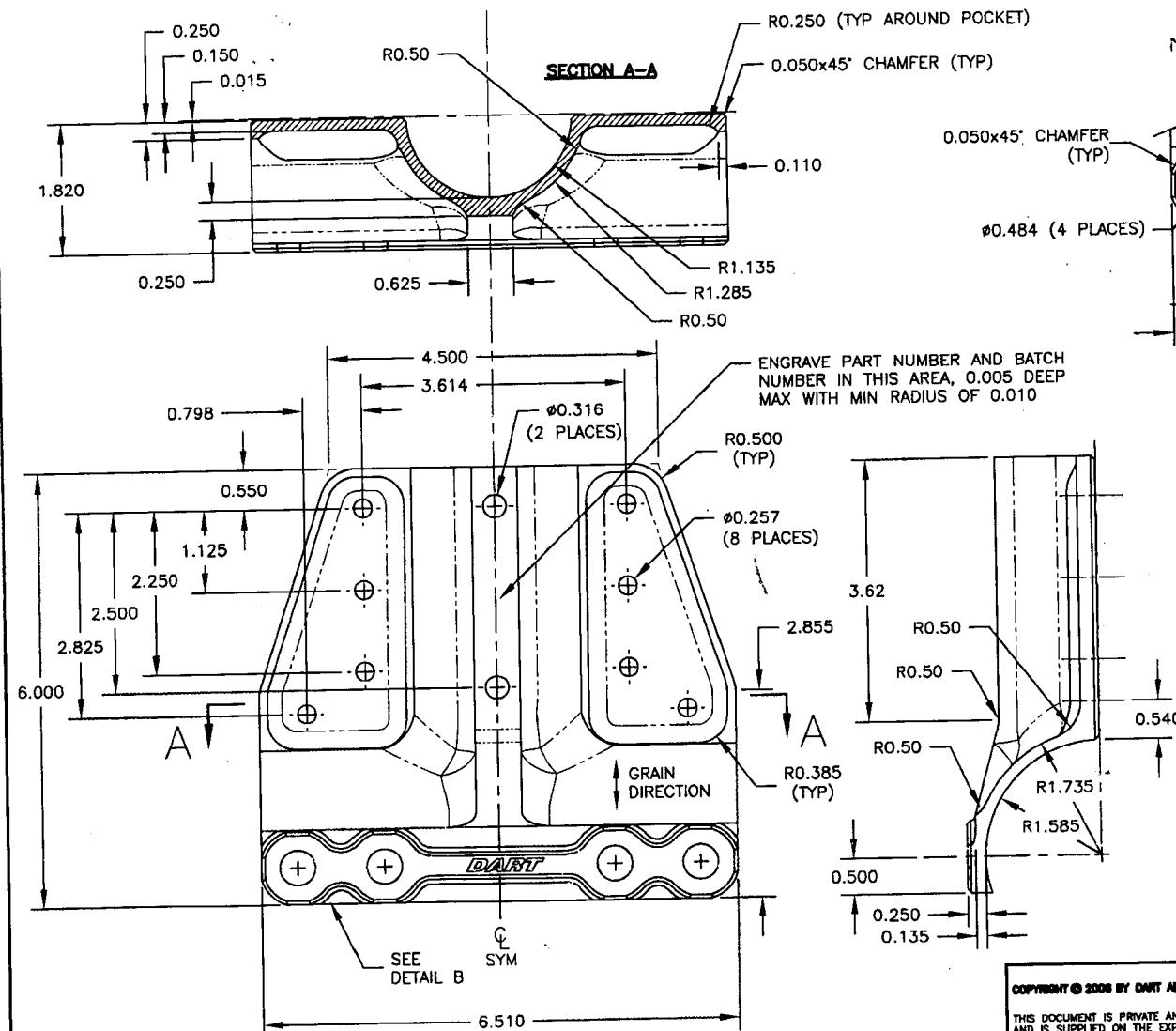
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 120311 MLJ
1406-06

ENgrave DART LOGO IN
THIS AREA TO A MAX
DEPTH OF 0.015 AND A MIN.
TOOL RADIUS OF 0.250



D3500-1 SADDLE

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11)
(MAKE FROM D6102-013 SADDLE BILLET, 6061)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1,
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

RELEASED

06-08-15 *ff*

C	06.06.30	MAT'L NOW 6061-T6/T651
B	06.05.29	CHANGE DIMS; MAT'L NOW 7075-T7351
A	06.04.18	NEW ISSUE
DESIGN	DRAWN BY	DART
90	PH	DART AEROSPACE LTD. MURRAY, ONTARIO, CANADA
REVIEWED	APPROVED	DRAWING NO.
<i>ff</i>	<i>ff</i>	D3500
DATE	TITLE	SCALE
06.06.30	SADDLE	2:3

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DART AEROSPACE LTD.

REV. C

SHEET 1 OF 1

SCALE

2:3